Work Order January-23-13 10:.			*961	54*							Page	1
Revision ID:	2369-1		Accept	*N900	040	100)*	Setup S	tart Stop	*NS	S1* S2*	
	01/13 Start Qty: 8.00	• •		Cust Item I Customer:	D:					"IV.		
	rocess Plan: <u>MU5</u>	- ,	Tooling: SPC (Y/N):	1 12 12	ate:		Ī		tart Stop		R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D2369	Rev A											
*100	FLOW WATER JET		0.00				8				0A5 05 05	13.01.22
Waterjet FLOW CNC Waterjet SSR · OYO		s per Dwg D2369 Dwg Rev:	0.00 Prog Rev:	2-								
110	QC2- Inspect parts of	off machine FAI/FAIB	0.00				8			(0AS 05 25	
110 QC Quality Control	Memo		0.00								8-8 9	13.04.22
¹²⁰ *12∩*	QC8- Inspect parts -	second check	0.00 QAS	_1,			(19)					
QC Quality Control	Memo		0.00 ^{ALGO}	13/14/12			100					_

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	IFORN	MANCE / UPDA		QA Closed:	Date:	
Manle Onde		H. 2		:	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde Part N NCR N	lo				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	li	nitial	Actio	n	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chi	ief Eng	Descrip	tion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator				ļ		}						
Material												
Setup											<u> </u>	
Other												
Process												
Supplier												
Training												
Unapproved									····			
					F	<u>AUL</u>	T CATE	GORY				-
Landi	ng Gear				General	_			F	,		-
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed,	Crimped.			Burrs		Instruct	ions Incomplete/Un	clear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Tre	at			Countersink		Mislabe	eled		Positioned V	Vrong	_

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord January-23-13	•			*96154*								
Item ID: Revision ID: Item Name:	D2369-1 Deck Plate Le	ocator Brackets		Accept	*N900	040	100)*	Setup	Start Stop	I VI	S1* S2*
Start Date: Required Date: Reference:	2/01/13 : 2/01/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	ID:						. 12
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	171	R1* R2*
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & St Memo	ock Location	Set Up/ Run Hours UIA 0.00	Tool ID	Tool#	Plan Code	Accep Qty	ot Re Qt		Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC21- Final Inspection -	- Work Order Release	0.00					12)4	23(X)
										(A)	KPON!	λ <i>)</i> ,

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Engineering Rework Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Quality Part No. Scrap Other Thermoforming Finishing Rec/Store/Packaging Use-as-is Work Order Update Large Fab Composite Supplier NCR No. Description of work order update Initial Sign & Action Root Verification QC Inspector Description Qty or Non-conformance Chief Eng Date Cause Date Step Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY** La

ndin	g Gear	General			_		_
Γ	Bending	Bend		Grain	Ovalized		Pressure/Forced
Γ	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	L	Temperature/Cure
	Cracks	Broken/Damaged	Γ	Inspection Incomplete	Part Incorrect	L	Weld
Γ	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination	Γ	Maintenance	Part Moved		
ſ	Heat Treat	Countersink		Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge		Other
Ī	Ripples in Bend	Drill Holes	Γ	Offset	 		
Ī	Torque Waves in Extrusion	Drawing	Γ	Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio	Γ	Outside Dimensions			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-23-13 10:55:15 AM

Work Order ID:

96154

Parent Item:

D2369-1

Parent Item Name:

Deck Plate Locator Brackets

Start Date: 2/01/13

Required Date: 2/01/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev A Removed from 9 Digit 05-12-05 JLM

	IPP Rev:B now	water jet	07-12-	וו טט									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	101.7789	1.354	11.402106		1 .0	1 00
5052-H32 .040 Sheet											- W	(1).0	9· aa

Location	Loc Qty	Loc Code	
MAT022	101.778945		124573
119384	45.578945		<u></u>
122406	56.2		

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	ONFORM	MANCE / UI		QA Closed:	Date:	
Mark Ordan	•				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Order: Part No.					Rework Scrap Use-as-is	r	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.	·				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	А	ction	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator									·		
Material											
Setup											
Other											
Process											
Supplier											
Training		1	1								i ,

FAULT CATEGORY

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Unapproved

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

DART AEROSPACE LTD	Work Order:	96/54
Description: Deck Plate Locator Bracket	Part Number:	D2369-1
Inspection Dwg: D2369 Rev: A		Page 1 of 1

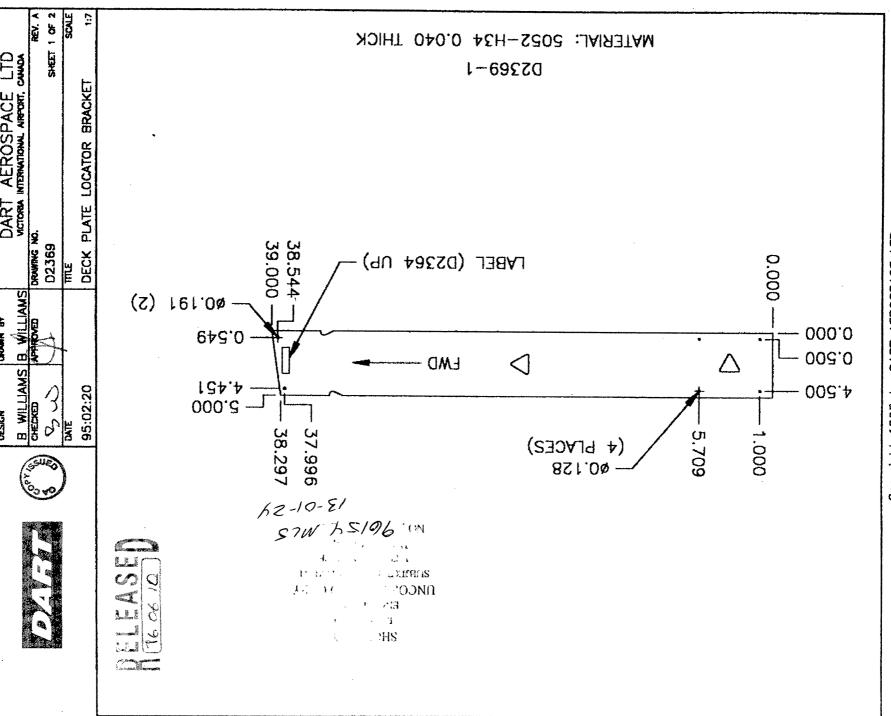
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.494	/		٧	JKM-01
4.500	+/-0.010	4.491	/		٧	
1.000	+/-0.010	0.995			V	
5.709	+/-0.010	5.701	1		V	
37.996	+/-0.010	37.996	/		V	JKM.04
38.297	+/-0.010	38. 297	/		Ť	
5.000	+/-0.010	5.004	/		V	
4.451	+/-0.010	4.455	/		V	
0.549	+/-0.010	0.548	✓		V	
Ø0.191	+0.005/-0.000	0.191	V		\	
Ø0.128	+0.005/-0.000	0.128	V		V	
39.000	+/-0.010	39.00	\ \		T	
38.544	+/-0.010	38.544	V		Ť	

Measured by:	Mul	Audited by:	OAS	Prototype Approval:	N/A
Date:	13.04.22	Date:	9-65 Blulzz	Date:	N/A

Rev	Date	Change		Revised by	Approy €d
Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM C	411



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SOFE SHEET 2 OF 2 MATERIAL: 5052-H34 0.040 THICK $\Sigma - 69\Sigma ZQ$ PLATE LOCATOR BRACKETS 38.528 39.000 02369 DECK H LABEL (D2344 UP) APROVED 000.0 499.0 009.0 - LMD B WILLIAMS CHECKED 000.2 005,4 95:02:20 38.297 37.990 5.709 1.000 (6 PLACES) 821,0¢ 45196

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